Work Order ID 66857 Page 1 Tuesday, March 01, 2011 8:04:43 AM D3480-043 Item ID: Accept Setup Start **Revision ID:** Stop Eveball Adapter Item Name: **Start Date:** 3/1/2011 Start Qty: 2.00 **Cust Item ID:** Required Date: 3/7/2011 Rea'd Otv: 2.00 **Customer:** Reference: Run Start Tooling: Approvals: Date: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Run Hours Code Qty Oty Number Stamp Draw Nbr **Revision Nbr** D3480 Rev C 100 0.00 Small Fab Small Fab 0.00 Memo =>m/ 11/03/10 Small Fab Spot weld as per dwg D3480 110 QC11- Inspect spot weld per OSI004 0.00 QC 0.00 Memo Quality Control

120

QC

QC5- Inspect part completeness to step on W/O

0.00

Sis ilostio



Quality Control

Memo

0.00

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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes I	No DQ	A:	Date: _	
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Work Order ID 66857

Tuesday, March 01, 2011 8:04:43 AM



Page 2

Item ID:

D3480-043

Accept

Setup Start

Stop

Item Name: **Start Date:**

Required Date: 3/7/2011

Revision ID:

3/1/2011

Eyeball Adapter

Start Oty: 2.00 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Start

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

Tool ID

Date:

Tool# Plan Code

Accept Qty

Run

Reject **Qty**

Reject Insp. Number Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/3/10 A) P(11-03-10 (2)

Dart Aerospace Ltd

W/O:	-		W	ORK ORDER CHANG	GES					·
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Picklist Print

Tuesday, March 01, 2011 8:04:49 AM

Work Order ID: 66857

Parent Item:

D3480-043

Parent Item Name: Eyeball Adapter



Start Date: 3/1/2011

Required Date: 3/7/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3480-1		Manufactured	No			100	Each	9.0000	1 	² Ss	ulo	3/09
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					28809		型1		_	_1	-	
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NAS1031C3W		Purchased	No			100	Each	31.0000	4	8		
Nutplate										S	((03	/09
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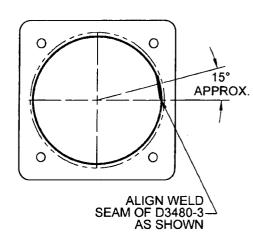
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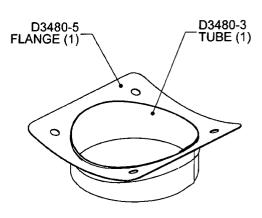
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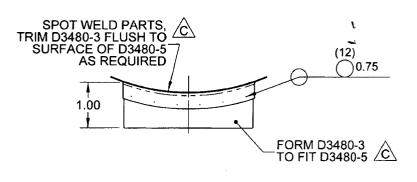


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DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
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	PH	-#	D3480	SHEET 1 OF 6			
DATE			TITLE	SCALE			
	08.	12.19	EYEBALL ADAPTER	1:2			
Α	O	6.02.06	NEW ISSUE				
В	0	6.08.29	D3480-3 0.50 was 0.40/D3480-3F	8.930 was 9.330			
С	0	8.12.19	D3480-3 PICTORIAL CHG PER D & 4); ADD/REV TOL (SHT 3-5); AL (SHT 4); MATL SPEC WAS MIL-S	DD MFG NOTE			









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D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3480-041 USING
- FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION	
X	D3480-041	EYEBALL INLET ADAPTER	
1	D3480-3	TUBE	
1	D3480-5	FLANGE	

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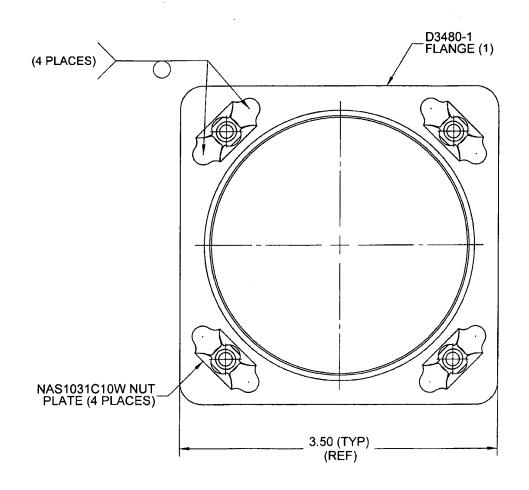
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section Section	ion C	Chief Eng	QC Inspector

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DATE	,,,,	TITLE	SCALE
08	.12.19	EYEBALL ADAPTER	1:1





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D3480-043 EYEBALL ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
Х	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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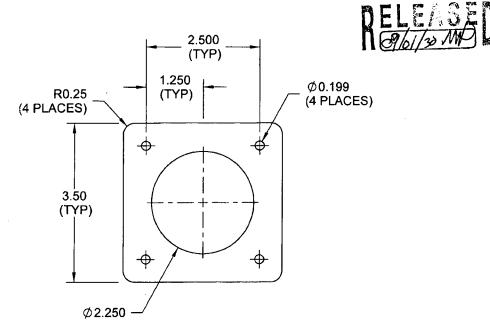
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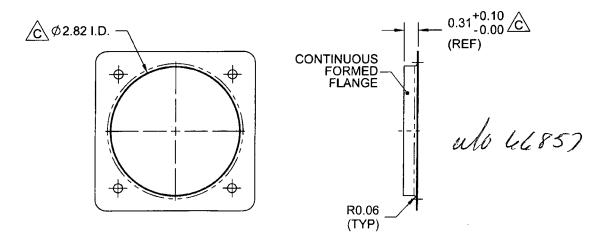
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P#	94	D3460	SHEET 3 OF 6
DATE		TITLE	SCALE
08	.12.19	EYEBALL ADAPTE	ER 1:2



D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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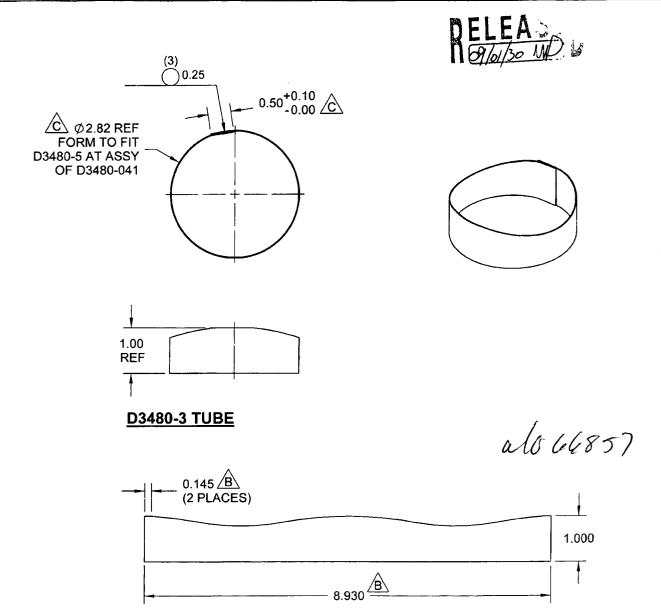
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DATE 08.	12.19	EYEBALL ADAPTER	SCALE 1:2



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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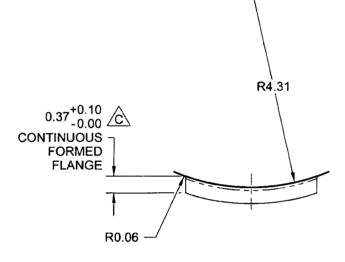
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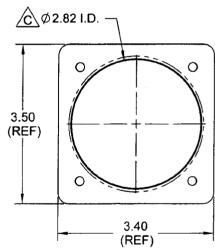


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DATE	.12.19	EYEBALL ADAPTI	SCALE





RELEASED



alo 4857

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

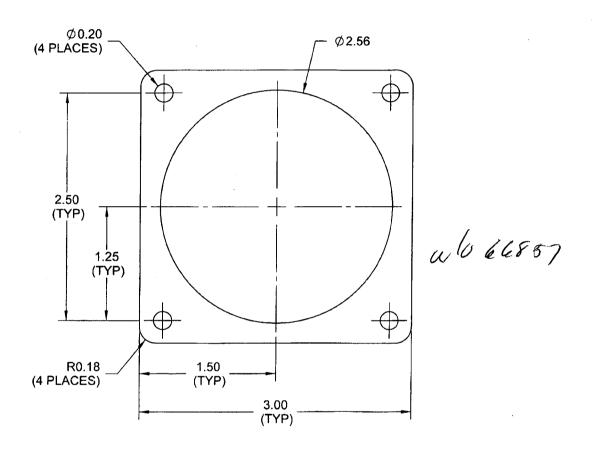
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DATE		TITLE	SCALE
08.	12.19	EYEBALL ADAPTER	1:1



D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, O.125" THICK (REF. DART SPEC. M-SIL60-.125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD AMS-W-6858A CLAŜS 'C '

		1ES1 NO#. 94								
EMPLOYEE: Man. Treg	فدر									
PART NUMBER: 13480	643	JOB NUMBER: b 66857								
MATERIAL TYPE: 304 L		MATERIAL THICKNESS:O(3								
GROUP SPECIFICATION		Group 1: Aluminum & magnesium Group 2: Iron; nickel; cobalt Group 3: Titanium								
TEST RESULTS										
PASS	FAIL	;								
VISUAL: [] PENETRATION: [] PULL STRENGTH: []	[]								
Qualified in accordance with sta	ndard Al	MS-W-6858A and QSI 004 (ref: 4.3)								
DATE OF TEST COUPON: 1(63/6) QUALIFIER:SS	<u></u>									